



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D135-1027-141
Job Sheet 190548



Part No: D135-1027-141

Job Qty: 1 pcs

Part Name: STD HEIGHT FWD Crosstube Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/11/19

Job Tracking No:

Due Date: 3/29/19

Created By: Jesse White

Type: Stock

Description: SIOP

Note: D135-1027-141 REV.B IPP REV:A 17.09.05 NEW ISSUE DD VERF:DP IPP REV:B 18.11.08 AS PER DWG
REV.B DD VERF:JFS

Ship Via:

Chg 001 Del

Bill of Materials

Route updated

DAS 35 89

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Crosstubes - 1	1 pcs		3/29/19	0.00	0.25	Crosstubes - 1		
							Crosstubes - 2		
							Crosstubes - 3		
							Crosstubes - 4		<i>AR 19-7-23</i>
110	QC 7	1 pcs		3/29/19	0.00	0.00	QC 7 - 10		
							QC 7 - 13		
							QC 7 - 14		
							QC 7 - 15		
							QC 7 - 17		
							QC 7 - 18		
							QC 7 - 19		
							QC 7 - 2		
							QC 7 - 28		
							QC 7 - 3		
							QC 7 - 30		
							QC 7 - 34		
							QC 7 - 36		
							QC 7 - 37		
							QC 7 - 41		<i>AR 19-7-27</i>
							QC 7 - 47		
							QC 7 - 48		
							QC 7 - 51		
							QC 7 - 58		
							QC 7 - 59		
							QC 7 - 6		
							QC 7 - 60		
							QC 7 - 9		
							QC 7 - 68		
							QC 7 - 50		
							QC 7 - 67		



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CANADA
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Container No: S199726



Part: D135-1027-141

Job No: 190548

Serial No/Batch: S199726

Revision: B

Inspector:

Exp Date:

Instructions: TC STC SH18-49 Issue 1, FAA STC SR04276NY dated 18/11/21, E

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS					
		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Date :		Sequence #:		QTY Affected :			MRB (QSI042) Completed By Lead hand / Supervisor QC / QA Coordinator		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread				
		Other/Details:							

120	Handfinish - 1-2- Chemical-B4B	1 pcs	3/29/19	0.00 0.25	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	AB 19-7-28
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
140	Spray Paint - 2 - B4B	1 pcs	3/29/19	0.00 1.00	Spray Paint - 1 - B4B	AB 19-8-1
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
150	QC 14	1 pcs	3/29/19	0.00 0.00	QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	DAS
					QC 14 - 51	19
					QC 14 - 58	9-89
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
155	Handfinish - 4-2-Assembly-B4B	1 pcs	3/29/19	0.00 0.67	Handfinish - 4 - 1 - B4B	
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	RD 19-8-6
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
					160 QC 5	1 pcs
QC 5 - 12						
QC 5 - 17						
QC 5 - 18						
QC 5 - 19						
QC 5 - 22						
QC 5 - 24						
QC 5 - 3						
QC 5 - 42						
QC 5 - 43						
QC 5 - 49						
QC 5 - 51						
QC 5 - 58						
QC 5 - 68						
QC 5 - 9	DAS AUG 12 2019 9-89					
QC 5 - 50						
QC 5 - 30						
170 Packaging 3-1 - Stock - B4B	1 pcs	3/29/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B	DAS AUG 12 2019 9-89	
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
					Plex 2/11/19 11:47 AM dart.white.jesse	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

180 QC 21 - SA

1
pcs

3/29/19

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 53

Part Op 100 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1) ***PRIOR TO CHEMICAL CONVERSION*** SCRIBE
 Descriptions: DART P/N AND B/N ON INSIDE OF CUFF PER QSI 044 6.4

110 - QC7-5 (QC7-Inspect Chemical Conversion Coat)

120 - INSTALL THREADED ROD AS PER DWG AND APPLY LOCKTITE 263 (NOTE 9) AND SEAL BETWEEN THE NUT AND CROSSTUBE USING SEALANT(NOTE10)

140 - Spray Paint (Spray Paint / NDT Room) ***MASK PRIOR TO PRIME AND PAINT AS PER NOTE11, BOTH ENDS***

1- PRIME INSIDE AND OUTSIDE PER QSI005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER) BATCH: 5189559

2- PAINT OUTSIDE SURFACE AS PER QSI005 4.2.2.4 (FLOAT SKIDTUBE PAINT) BATCH: 5192331 3-

COAT INSIDE SURFACE WITH LPS PROCYON AS PER DWG, QSI005 4.8 4- AFTER FINISH APPLY A 1 INCH CENTER LINE ON TOP OF CROSSTUBE WITHIN 0.1" OF CENTERLINE QSI 044 6.1(SEE NOTE 12 AND 13)

150 - (QC14- Inspect Spray Paint)

155 - ***CROSSTUBE*** ASSEMBLE AS PER DWG NOTE 13. USE SOAP AND WATER IF NECESSARY AS PER DWG NOTE 14. TORQUE BOLT TO 50-70 IN-LBS AS PER NOTE 13.

160 - (QC5- Inspect part completeness to step on W/O)

170 - (Identify as per dwg & Stock Location:_____)

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D135-1027-151	Std Height Fwd Crosstube	1 pcs (1 ea)	100-Crosstubes - 1	<u>5164544</u>
D5511-1	Threaded Rod	2 pcs (2 ea)	100-Crosstubes - 1	<u>5192214</u>
MS35650-304	Nut	4 Ea (4 ea)	100-Crosstubes - 1	<u>5155670</u>
NAS1149D0363J	Washer	4 Ea (4 ea)	100-Crosstubes - 1	<u>5176545</u>
D5411-1	Rubber Bushing	2 pcs (2 ea)	155-Handfinish - 4-2-Assembly-B4B	<u>518151241</u>
D5412-041	Crosstube Clamp Assembly	2 pcs (2 ea)	155-Handfinish - 4-2-Assembly-B4B	<u>5167693</u>
D5413-1	Crosstube Support	2 pcs (2 ea)	155-Handfinish - 4-2-Assembly-B4B	<u>5163846</u>
D5414-1	Support Bolt	4 pcs (4 ea)	155-Handfinish - 4-2-Assembly-B4B	<u>5158859</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Crosstubes - 1	D135-1027-151	1	0	0
	D5511-1	2	17	0
	MS35650-304	4	20	0
	NAS1149D0363J	4	796	0
	D5411-1	2	30	0
155-Handfinish - 4-2-Assembly-B4B	D5412-041	2	16	0
	D5413-1	2	16	0
	D5414-1	4	38	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

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Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
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Other/Details:					

Change Record

PAGE 1 OF 1

Part Number: D135-1027-141

Description: STD HEIGHT FWD CROSSTUBE ASSEMBLY

[illegible]